

Work Order ID 55045

January 5, 2010 1:49:18 PM



Page 1

Item ID: D3208-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *RP*

Date: 10-1-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3208

Rev A1

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut blank: 4.038" X 5.340" grain along 4.038" Identify for D3208-1

EP 10/01/21 (10)

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Drill and Fillet D3208-1 corner as per Dwg D3208 Identify as D3208-1

EP 10/01/21 (10)

120

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr D3208-1 Form D3208-1 as per Dwg D3208 Polish any marks on part within 01. of Dwg D3208

SB 12/02/03
EP 10/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55045

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Item ID: D3208-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



⇒ 8/10/02/04

QC

Memo

0.00

(X10)

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



BR 10-02-05

HandFinish

Memo

0.00

(10)

Hand Finishing

150

QC3- Inspect Part Finish

0.00



MS 10-02-05

QC

Memo

0.00

(X10)

Quality Control

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Work Order ID 55045



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January 5, 2010 1:49:18 PM

Item ID: D3208-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 05/01/2010 Start Qty: 600



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 600



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: ST
202

0.00

Packaging

Memo

0.00

Packaging

16/2/9 (10)

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/11 AJ
MF 10-2-9

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 1:49:23 PM

Page 1

Work Order ID: 55045

Parent Item: D3208-1

Parent Item Name: Doubler


Comments:

Start Date: 05/01/2010

Required Date: 15/01/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	523.1628	1.0389			
												
2024-T3 .040 sheet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

523.1627789

110305

192

110337

6.4

111786

32.0665789

112291

50.1264

112331

82.8641

113162

159.7057

EB 10/01/21

1.0389

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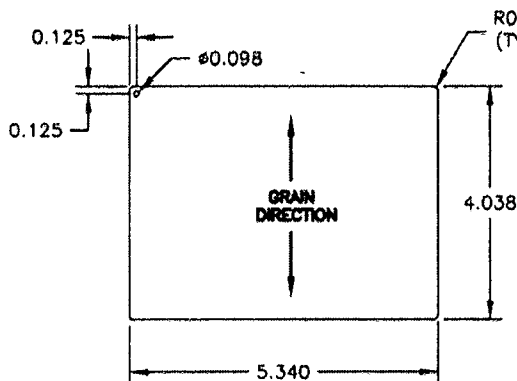
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CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3

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04 04 05

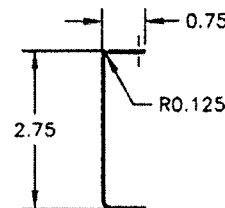
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A1	#	04.01.27

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SUBJECT TO AMENDMENT
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WORK ORDER

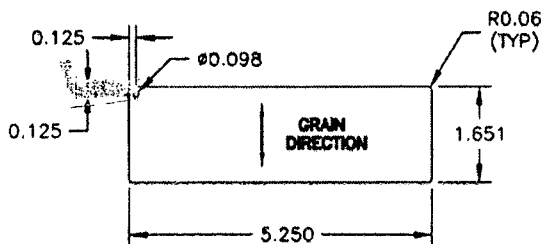
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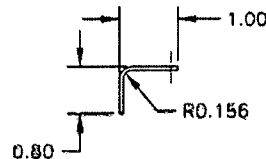
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



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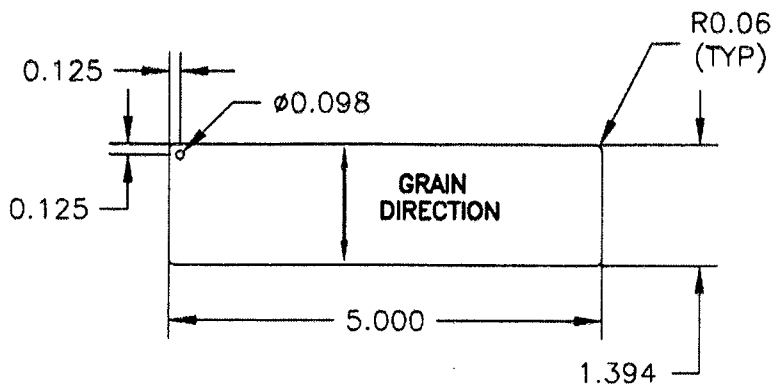
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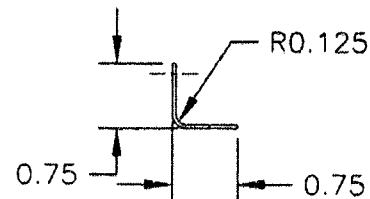
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W/O 55645

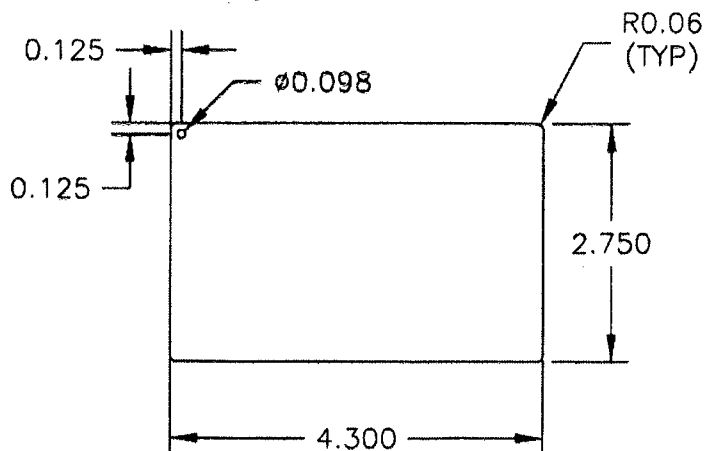
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04.04.05



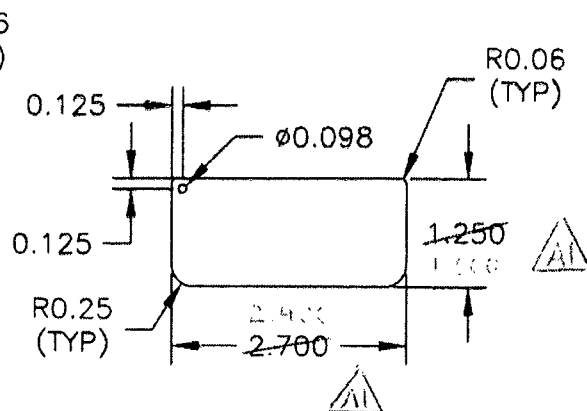
2 D3208-5 MOUNT ANGLE
FLAT PATTERN



D3208-5 MOUNT ANGLE
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

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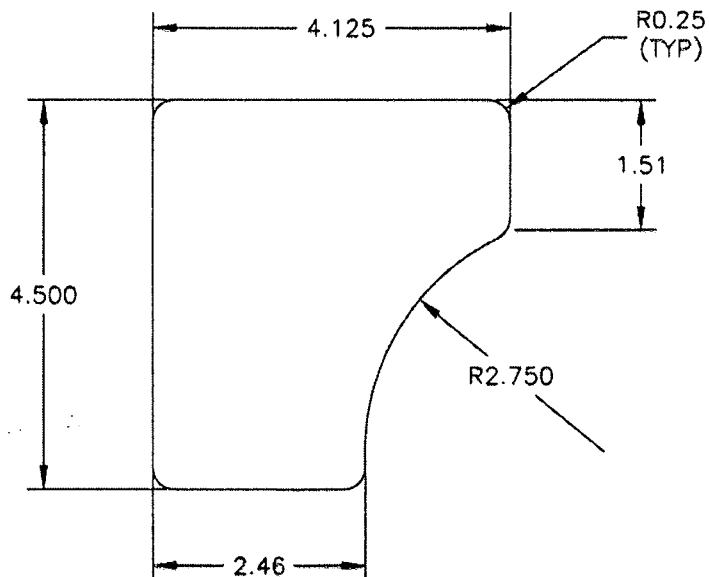
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w/o 55045

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D3208-9 DOUBLER

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